

1 What is claimed is:

2
3 1. A method of installing a gasket in a socket end of a thermoplastic pipe which is used to form
4 a pipe coupling, the method comprising the steps of:

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6 providing a mandrel with an inner end and an outer end and having a generally cylindrical
7 outer working surface;

8
9 installing a gasket at a first circumferential position on the outer working surface, the gasket
10 having at least selected surfaces coated with an external polyurethane anti-corrosion and anti-friction
11 coating;

12
13 providing a retention member at a second circumferential location on the mandrel nearer the
14 inner end of the mandrel, the retention member abutting the gasket in a normally extended position
15 but being retractable to a retracted position in a subsequent manufacturing step;

16
17 heating a socket end of the thermoplastic pipe;

18
19 forcing the heated socket end of the thermoplastic pipe over the working surface of the
20 mandrel and over the gasket with the retention member being in the extended position, whereby the
21 heated socket end of the thermoplastic pipe flows over the gasket to form a retention groove for
22 retaining the gasket and again contacts the working surface of the mandrel;

23
24 cooling the heated socket end of the thermoplastic pipe;

25
26 retracting the cooled socket end of the thermoplastic pipe and the retained gasket from the
27 working surface of the mandrel.

1 2. The method of claim 1, wherein the coating when cured has the following published physical
2 properties:

3
4 Tensile strength ASTM D 412 5000psi
5 Method A, Die C

6
7 Percent Elongation
8 ASTM D 412 Method A, Die C 500 percent

9
10 Taber Abraser
11 CS17 1000 g/1000 cycles No loss

12
13 Durometer Shore A 110
14

15 3. The method of claim 1, wherein the external coating is sprayed on.
16

17 4. The method of claim 1, wherein the gasket is an elastomeric, ring shaped member having a
18 circumferential contact area and an exterior surface, and wherein the coating is applied to at least
19 selected portions of the circumferential contact area.
20

21 5. An improved sealing gasket for sealing fluid conveying piping systems, the gasket
22 comprising:

23
24 an elastomeric, ring shaped member having a circumferential contact area and an exterior
25 surface, and wherein an external polyurethan coating is applied to at least selected portions of the
26 circumferential contact area.
27
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6. The gasket of claim 5, wherein the coating when cured has the following published physical properties:

Tensile strength ASTM D 412	5000psi
Method A, Die C	

Percent Elongation

ASTM D 412 Method A, Die C	500 percent
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Taber Abraser

CS17 1000 g/1000 cycles	No loss
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Durometer Shore A	110
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